Work Order II February-24-14 9:59		9 3	*11	3603*						Page 1
Item ID: D353 Revision ID: Item Name: Gaske	16-41 D 3 5 3 6 -	- 41	Accept	*N90	00040	າ1ດ()*	Setup Star Stop	171	S1* S2*
Start Date: 2/24/ Required Date: 2/24/ Reference:	• •	*8* *8*	27)	Cust It Custon						,
Approvals: Pro		Date: <u> \</u> -\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-	Tooling: SPC (Y/N):		Date:		I	Run Star Stoj	^ \]	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hour	Tool 1	D Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			•		W-W/		-		
D3536	Rev A									
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per D Deburr if neces	wg D3536 Dwg Rev ssary	0.00 0.00 ————Prog Rev:_	<u>A</u> 2-			13	_0_		JM14-03-12
110 *110* QC Quality Control	QC2- Inspect parts off mac	hine FAI/FAIB	0.00	•		27	13			Jm14-03-12
120 *1 20* QC Quality Control	QC8- Inspect parts - second Memo	i check	0.00 1 9-8			(4	outs 127)		

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
	•					Rework			Skid-tube Crosstube	Γ]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR No.				Suspected Unapproved			Large Fab Composite	:	J	Supplier			
Root					Desc	ription of work order update	Ī	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Doc/Data													
Equip/Tooling											1		
Handling/Pre													
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Operator									1			i	
Offset/Setup			<u> </u>									:	
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Supplier													
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Unapproved							l		<u> </u>				1
							FA	ULT CA	TEGORY				
Landi	ng G	}			_	General		1		_	-		٦
	L.,	Bending				Bend	<u> </u>	•	Program	Ŀ	Outside Dim	<u> </u>	Pressure/Forced
		Centre No	ot Concei	ntric	<u> </u>	BOM/Route		Grain		-	Over/Under	<u> </u>	Set-up
	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		\vdash	Part Incorred	<u> </u>	Temperature/Cure
		Crimp/Kir	nk/Ripple	:/Wave	L	Burrs	_	4 '	tion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination	<u></u>	4	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled
	_	Crushing				Countersink	<u></u>	•	gned/off center	<u> </u>	Positioned V		٦
		Heat Trea			\vdash	Cut Too Short	<u></u>	Mislab		L	Power Loss/	Surge	Other
		Inspectio		Tube		Drawing	<u></u>	Misrea					
	<u></u>	Marks/Ch			<u> </u>	Drill Holes	_	Off-set					
	L	Turning S	•		_	Finish	\vdash	4	Calibration				
1	1	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

Work Ord February-24-14		3603		*119	3603*						Page 2
Item ID: Revision ID: Item Name:	D3536-41 Gasket Center	Aft		Accept	*N900	040	100)* s	etup Start Stop		S1* S2*
Start Date: Required Date Reference:	2/24/14 : 2/24/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:					
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:		R	un Start	~1 <i>V</i> 1	R1*
	QC:		Date:	SPC (Y/N):	D :	ate:			Stop	*N	R2*
Sequence ID/ Work Center I 130 *130*	ID	Operation Description Identify as per dwg & Ste	ock Location: [-12 0 0	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	Reject Number	Insp. Stamp
Packaging Packaging		Memo		0.00				4			
140		QC21- Final Inspection -	Work Order Release	0.00							
*1 4 \(\Delta\) QC Quality Control		Мето		0.00					Y1 E.	-03 ^	14 MF 14-3-14
											14-3-19

DQA:	Date:						TRAGG						
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI			–	AEROSPACE
QA Closed:			Date:							V	Vork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	•					Rework		Skid-tube Crosstube				Water Jet	Engineering
Part N	lo.).			Scrap		Machining Small Fab		Prod. Eng. Coor.		Quality		
	•					Use-as-is		Thermoforming Finishing		Rec/Store/Packaging		Other	
NCR No.			<u></u>	Suspected Unapproved			Large Fab	Composite		Supplier			
Root	٦				Desci	ription of work order update		nitial	T Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	l	ief Eng		ription	Date	Verification	QC Inspector
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Operator													
Offset/Setup													
Process													
Supplier													
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Transport													
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		Bending			L	Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up
	,	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	Inspect	tion Incomplete/U	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/l	Unclear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center	L	Positioned V	Vrong	
		Heat Trea	ıt			Cut Too Short		Mislab	eled	L	Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d		€m.	15th	
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish	L	Out of	Calibration				
	Wave/Twist in Tube			oe .		Fit/Function		Out of	Sequence				

February-24-14 9:59:22 AM

Work Order ID: 113603

113603

Parent Item:

D3536-41

D3536-41

Parent Item Name: Gasket Center Aft

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locati	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No	100	sf	366.1000	0.6804	6.048			
MNIEO60	C 062						**	0		Tn	ALL 63

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NEOPRENE SHEET 0.063

Locati	<u>on</u>	Loc Oty	Loc Code	
MAT0	52	366.1		<u></u>
	M126546	27.1		
	M128266	339		128266

DQA:			Date:											1	TRAACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF					_	AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only	<u> </u>	
Work Orde	or.					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		
Work Orac						Rework			Skid-tube	Crosstube		Water Jet			Engineering
Part N	lo.					Scrap			Machining	Small Fab	ᅥ	Pro	d. Eng. Coor.	┪ ゚	Quality
	-					Use-as-is		I ————————————————————————————————————		Finishing	\neg	Rec/Store/Packaging		7	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	1	
	•												· · ·		
Root					Desc	ription of work order update	_	nitial	Acti	ion		Sign &			
Cause	\Box	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	1	QC Inspector
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Unapproved		<u></u>					EAL	HT CA	TEGORY				<u></u>		· · · · · · · · · · · · · · · · · · ·
Landi				-		General	FA	OLI CA	IEGORT	·					-
Lanui		Bending				Bend		l _{Eolio} /F	Program	[Outside Dim	ensions [\neg_{Pr}	essure/Forced
	\vdash	Centre No	nt Concer	ntric		BOM/Route	\vdash	Grain	Togram			Over/Under	⊢	┥	et-up
		Cracks	or conce.	iciic		Broken/Damage/Defect	\vdash	Hardwa	are	ļ		Part Incorre			emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	4	ion Incomplete/Ur	ngualified		Part Lost/Mi	ssing	—	'eld
	\vdash	Cuffs	4	,		Contamination		4	tions Incomplete/L			Part Moved		٦w	rong Stock Pulled
 				Countersink		4	gned/off center			Positioned V					
		Heat Trea	at			Cut Too Short		Mislab	-			Power Loss/	Surge	<u></u>]o	ther
		Inspectio		Tube		Drawing		Misrea	d						
		Marks/Cl	-			Drill Holes		Off-set							
		Turning S				Finish		Out of	Calibration						
	Wave/Twist in Tube			эе		Fit/Function	Г	Out of	Sequence						

DART AEROSPACE LTD	Work Order:	1/3603
Description: Gasket	Part Number:	D3536-41
Inspection Dwg: D3536 Rev: A		Page 1 of 1

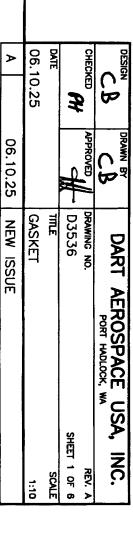
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.98	+/-0.030	27.98"	-		丁	Jano 3
25.08	+/-0.030	25.08	_		ケ	
18.50	+/-0.030	18.50"	_		T	
15.00	+/-0.030	(5.00	_		ーナ	
12.47	+/-0.030	12.47	_		T	
8.97	+/-0.030	8,97"	_		V	Imoi
6.93	+/-0.030	6.93"			ν	
3.43	+/-0.030	3.43		-	V	
2.00	+/-0.030	200	-		V	
4.00	+/-0.030	4.00	_		ν	
Ø0.19	+0.005/-0.001	0.19	_		٧	
3.90	+/-0.030	3.90	_		V	
1.88	+/-0.030	l.88°	_		V	
0.30	+/-0.030	0.30	-		V	
0.30	+/-0.030	0.30	-		V	
0.063	+/-0.010	0.063	_		V	

Measured by:	1m	Audited by:	16	Prototype Approval:	N/A
Date:	14-03-12	Date:	9-89 14/03/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	R

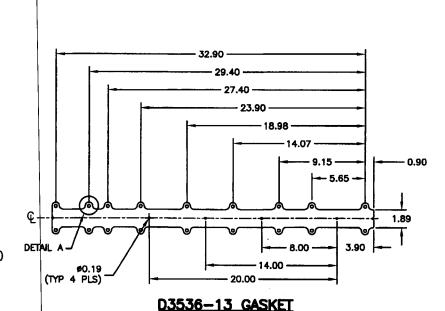




113603_MLJ 14-02-24

21.15 17.65 13.40 9.15 	26.65	
Q 1.89 DETAIL A 8.00 3.90 (TYP 3 PLS)	17.65 13.40 9.15 	

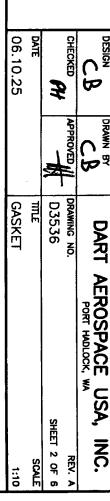
D3536-11 GASKET

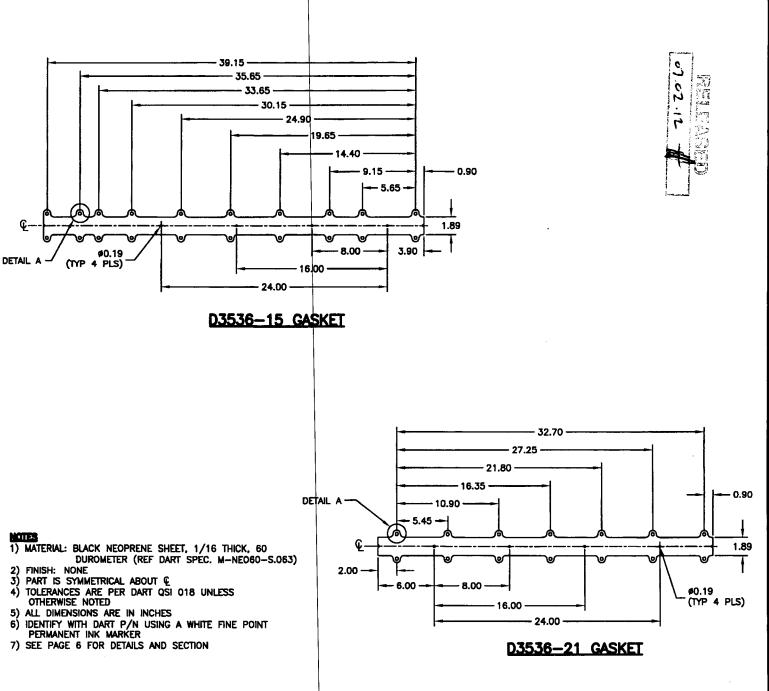


- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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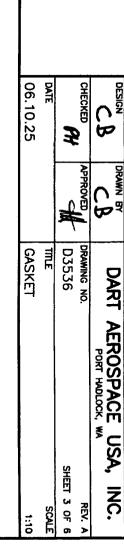


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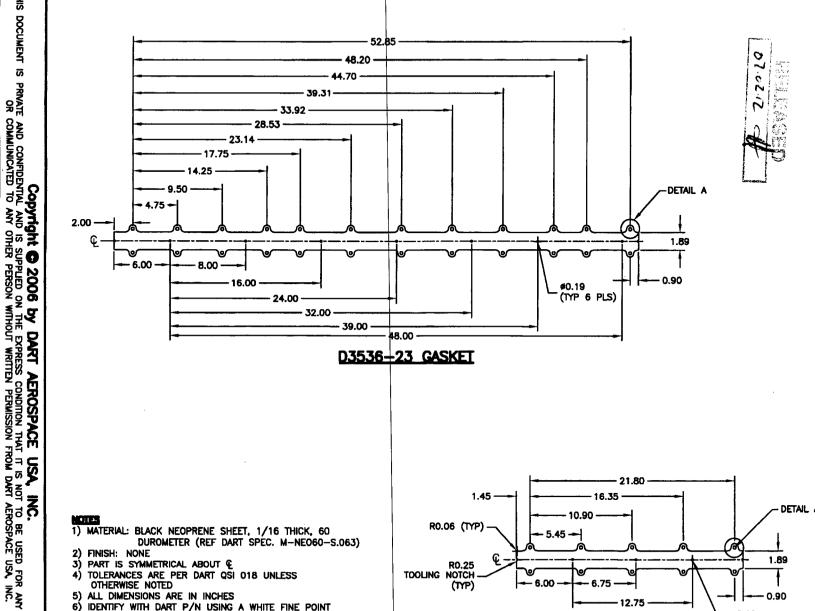
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D3536-25 GASKET

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TOOLING NOTCH (TYP)

PURPOSE

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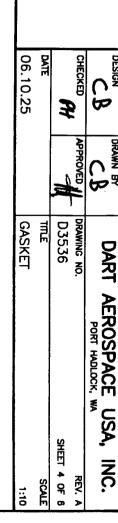
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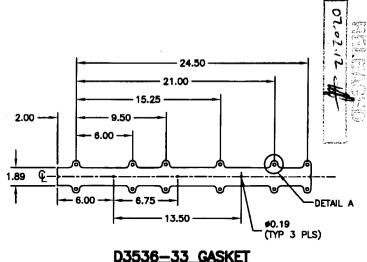
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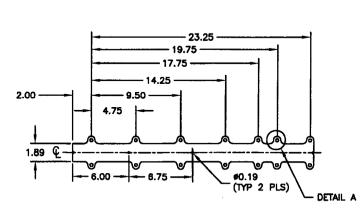
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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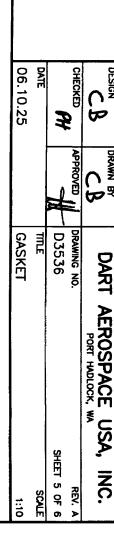


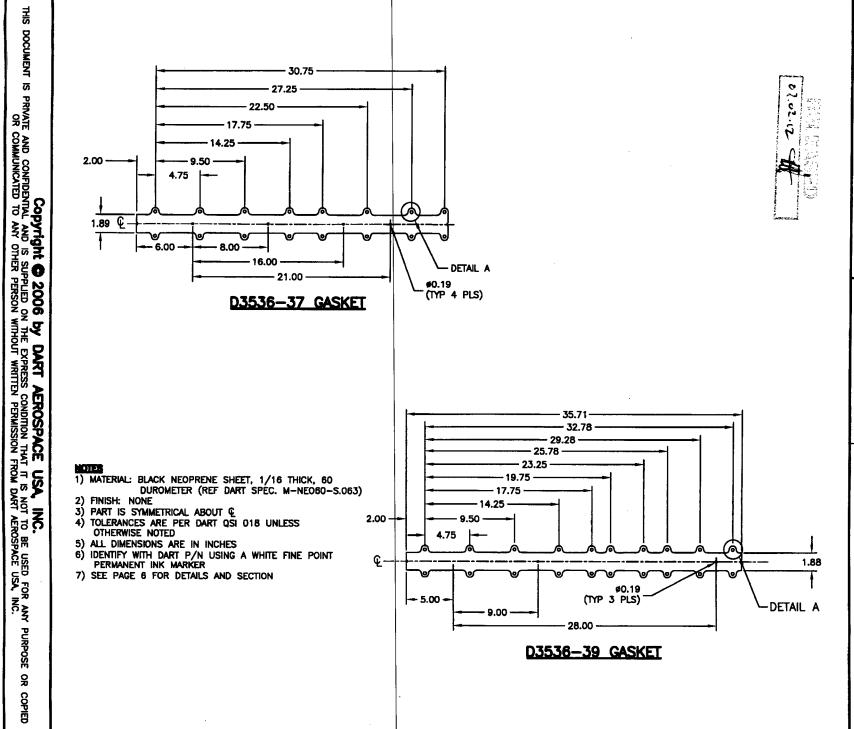
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- 2) FINSH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



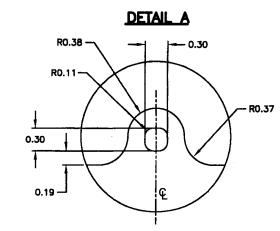


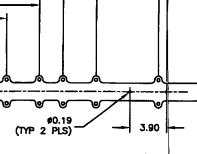




CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED //	DRAWING NO. REV. A
7	#	D3536 SHEET 6 OF 6
DATE		TITLE SCALE
06.10.25		CASKET 1.10







1.88

D3536-41 GASKET

27.98 25.08

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15.00 12.47 - 8.97

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DETAIL A

2.00 -

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- 101128 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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